



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4635-143
Job Sheet 167106-F



Part No: D4635-143

Job Qty: 1 ea

Part Name: Aft Ceiling Replacement Panel Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start Up Small Fab	
100	Small Fab	1 pcs		11/9/17	0.00	0.68	Small Fab	D.M.L. 17-12-28
110	Small Fab	1 pcs		11/10/17	0.00	0.68	Small Fab	D.M.L. 17-12-28
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	PD 17-12-28
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	D.M.L. 17-12-28
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4635-143 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M

3950 edge sealer (see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4635-3 5026667	1	2	0	0
	D4669-1 5022521	1	27	0	0
	D4669-3 5024520	1	38	0	0
	D4695-3 5024354	1	5	0	0
	D4732-1 5022518	1	6	0	0
	D4732-13 5022517	1	6	0	0
	D4732-37 5022516	1	3	0	0
	D5022-3 5022512	1	1	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____		DISPOSITION Rework ☐ Scrap ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machine ☐ Cross tube ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐	
Date : _____		MRB (QS1042) Approval _____ _____		Completed By _____	
Start up Operation Job No: 167106-F Mfg Date: 12/22/17		Change No: Operation: Revision: PART NO: D4635-143		Lead hand / Supervisor Approval Verification _____	
QC / QA Coordinator Approval _____		QC / QA Coordinator Approval _____		QC / QA Coordinator Approval _____	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		Supplier Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Centre Not Concentric Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	
OTHER : _____		BOM/Route Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	
Positioned Wrong Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		DART Aerospace S026665 Att Ceiling Replacement Panel Assembly, LH D4635-143 Operation: Revision: PART NO: Change No:		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	